

**Work Order ID 67149**

Page 1

Wednesday, March 09, 2011 12:49:12 PM

Item ID: D206-642-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *R*Date: *1-03-9*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-642

N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

*Silobor**For BG 11-4-26*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*C. P. R. B.*

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

Quality Control

*Silobor*

200  
B 67683

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67149**

Page 2

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Item ID: D206-642-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: _____ <i>F</i>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*11/6/11**11/6/11**11-06-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, March 09, 2011 12:49:18 PM

Page 1

Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC  
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec  
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev: M  
 09-03-02 as per DSI9440 rev.a verified by: EC  
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O  
 as per REV.N DD 10.04.19 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

8  
not  
D206-642-341  
Replacement Skidtube

Manufactured No

110

Each

3.0000

1

1

Location

Loc Qty

Loc Code

FG082

3

36550

1

44043

1

44044

1

8  
D206-648-013

CHG002

Manufactured No

110

Each

0.0000

1

1

GHW Modification

D2932-2

Manufactured No

110

Each

8.0000

1

1

5  
Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

4

66381

4

ST428A

4

62080

4

67683

B67297 11/04/2011

62080

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Wednesday, March 09, 2011 12:49:19 PM

Page 2

Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

S D2933-2  
Saddle RH In, 206

Manufactured No

110 Each

3.0000

1 1 ✓



JB SP

Location

Loc Qty

Loc Code

ST428

3

63585

3

63585

S D2938-2  
Saddle RH Out, 206

Manufactured No

110 Each

2.0000

1 1



669036 115265

Location

Loc Qty

Loc Code

ST421

2

66039

2

S D2939-2  
Saddle RH In, 206

Manufactured No

110 Each

5.0000

1 1



62050 JB 669031 116135

Location

Loc Qty

Loc Code

ST421

4

66385

4

ST428A

1

58268

1

S AN3-41A  
Bolt

Purchased No

110 Each

372.0000

8 8 ✓



SP JB 11/04/27

Location

Loc Qty

Loc Code

ST354

372

112431

1

114941

71

115936

100

116191

200

114941

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Wednesday, March 09, 2011 12:49:19 PM

Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110 Each

229.0000 16

16 ✓



Bushing



B66934

JB

SP

## Location

## Loc Qty

## Loc Code

FG	44
31985	44
ST019	185
65049	64
66124	121

MS21042L3

Purchased No

110 Each

2,376.000 8

8 ✓



Nut



JB SP

## Location

## Loc Qty

## Loc Code

ST300	2376
116391	776
116540	800
116549	800

AN960JD10

NAS1149D0363J Purchased

No

110 Each

24.0000 8

8 ✓



Washer



m116583 JB

11/04/21 SP

## Location

## Loc Qty

## Loc Code

ST	6
107715	6
ST335	18
105792	2
112279	16

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

110

Each

210.0000

4

4

✓



Bolt

Location

Loc Qty

Loc Code

ST337

210

115589

50

115700

10

116704

50

116924

50

117010

50



JB SP

AN5-11A

Purchased

No

110

Each

57.0000

4

4

✓



Bolt

Location

Loc Qty

Loc Code

ST337

55

116419

25

116978

30

ST338

2

115422

2



JB SP

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

34.0000

8

8

✓



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4



m 117291 JB 11/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, March 09, 2011 12:49:20 PM

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Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-6A

Purchased

No

110

Each

1,418.000

12

12

✓



Bolt

## Location

## Loc Qty

## Loc Code

ST356

1418

112933

96

113149

17

115108

5

115936

200

116191

300

116400

400

116924

400

116191

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

24

24

✓



Washer

## Location

## Loc Qty

## Loc Code

ST300

24

113288

24

ST356

6

115622

6

117065

MS21042L4

Purchased

No

110

Each

4,376.000

12

12

✓



Nut

## Location

## Loc Qty

## Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000

116188 x 6

116823 x 6

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, March 09, 2011 12:49:20 PM

Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

10.0000

1 1



Tow Ring



68339 Lu 11/04/11

Location

Loc Qty

Loc Code

ST420

8

66386

8

ST464

2

50387

1

64071

1

D3456-1

Manufactured No

110 Each

61.0000

1 1 ✓



Washer



B68748 JB SP

Location

Loc Qty

Loc Code

ST054

61

63239

2

64282

9

66848

50

D3457-1

Manufactured No

110 Each

25.0000

2 2 ✓



Washer



JB 11/04/2 SP

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

15

45913

1

66030

14

66030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4  
Nut

Purchased No

110 Each

823.0000

1

1

Location

Loc Qty

Loc Code

ST301

823

114523

5

114784

2

116188

516

116549

300

116188

AN4C5A

Purchased No

110 Each

434.0000

1

1

Location

Loc Qty

Loc Code

ST346

434

112243

434

112243

AN960C416

NAS1149C0463  
R

Purchased No

110 Each

29.0000

1

1

washer

Location

Loc Qty

Loc Code

ST346

29

100993

29

M116900 11/0427

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Wednesday, March 09, 2011 12:49:20 PM

Work Order ID: 67149

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

35.0000

1

1

✓



Ring



JB SP

## Location

## Loc Qty

## Loc Code

ST420

23

62961

9

66387

14

ST473

12

51586

1

53446

1

65294

10

65294

D2712

Manufactured No

110 Each

568.0000

10

10

✓



Set Screw



JB SP

## Location

## Loc Qty

## Loc Code

FG

50

29962

50

ST012

250

66955

250

ST021

268

61331

18

65115

250

65115

D2934

Manufactured No

110 Each

21.0000

2

2

✓



Saddle Spacer



JB 11/04/27 SP

## Location

## Loc Qty

## Loc Code

FG

6

31929

6

ST027

15

66043

15

66043

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Wednesday, March 09, 2011 12:49:21 PM

Work Order ID: 67149



Parent Item: D206-642-312



Parent Item Name: Skidtube RH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured

No

110

Each

80.0000

2

2



Saddle Spacer



JB 11/04/21

Location

Loc Qty

Loc Code

ST027

80

63558

9

66564

71

63558 x1  
66564 x1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.5 206 L/L-1/L-3/L-4/407 LOW &amp; HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG <sup>(1)</sup>
2B			14			D2651-3	* O-RING <sup>(1)</sup>
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			MS27039-1-08	* SCREW <sup>(1)</sup>
5			2			AN960JD10L	* WASHER <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT <sup>(2)</sup>
14	4	4				AN5-11A (OR AN5-12A)	* BOLT <sup>(2)</sup>
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: <sup>(1)</sup> DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE<sup>(2)</sup> CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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